

Date: Monday, 29/09/2008 11:54:49 AM  
 User: Julie Lecocq

## Process Sheet

SP117

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 42316  
 Estimate Number : 10256  
 P.O. Number :  
 This Issue : 29/09/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D22303  
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2230 REV F  
 Previous Run : 41334 Project Number : N/A  
 Drawing Revision : F  
 Material :  
 Due Date : 10/10/2008 Qty: 200 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08.9.29  
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: B39513 43722

2.0	BAND SAW	BAND SAW
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Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: B39513 43722

cut @ meter

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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RG



Issue P.O

7300



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

meter

C20810/02 (200)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RG

Review & inspect for transit damage  
Ensure C of C attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

inspect level 5



counters

S0812/11

(100)





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 42316

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FA3 RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble and deburr rough edges after tumbling

*n/a S 8/12/11*

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*100x MF 08/12/11*

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/12/11 100x*

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*M 109152 100x*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1=10  
320 OF  
1=50*

*MF 08/12/11*

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

*08-12-11 100x*

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *416*

*8/12/11 100x SD*

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/12/12*

Job Completion



*MF 08-12/11*





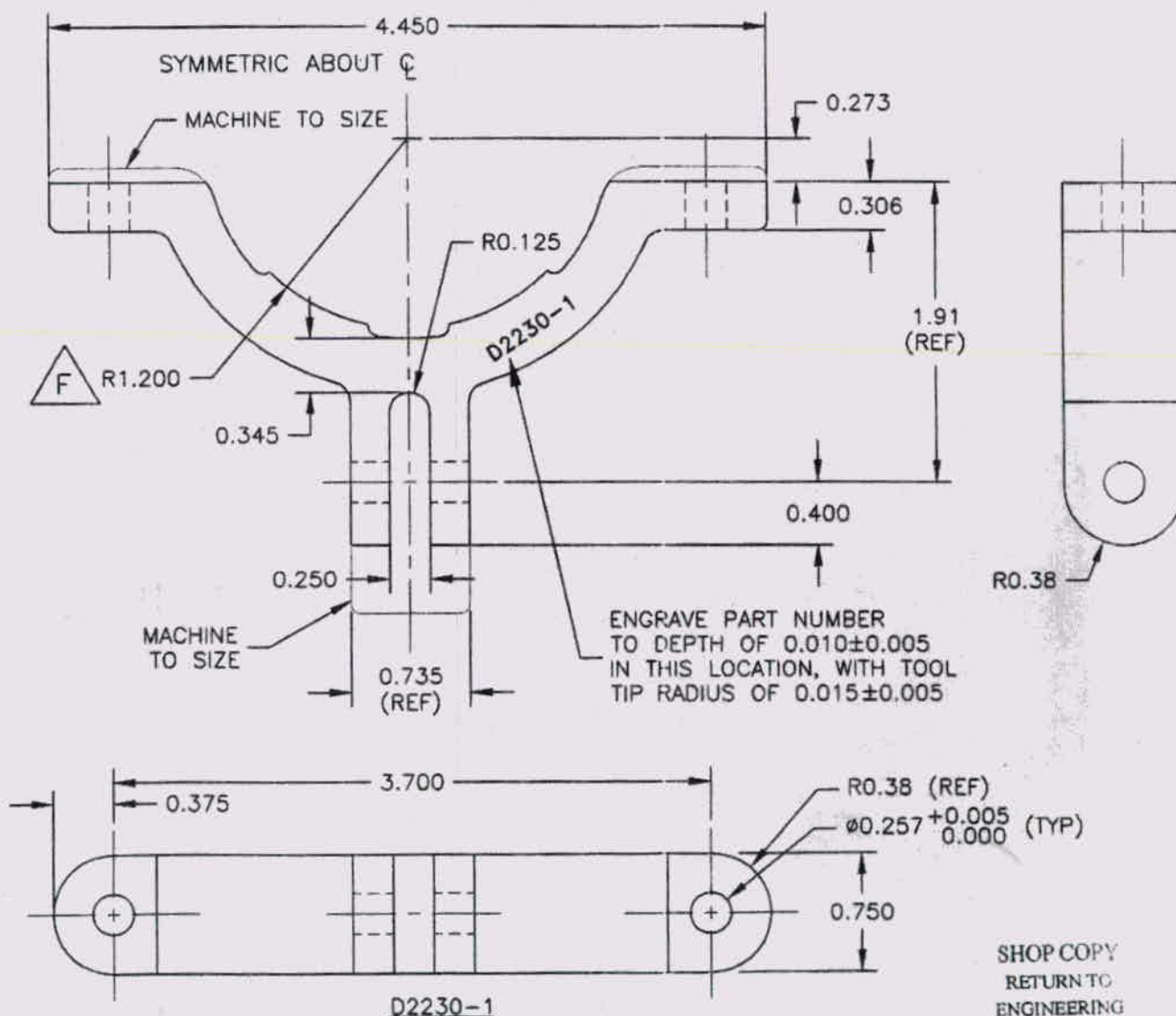






DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED  
99.12.21 DS

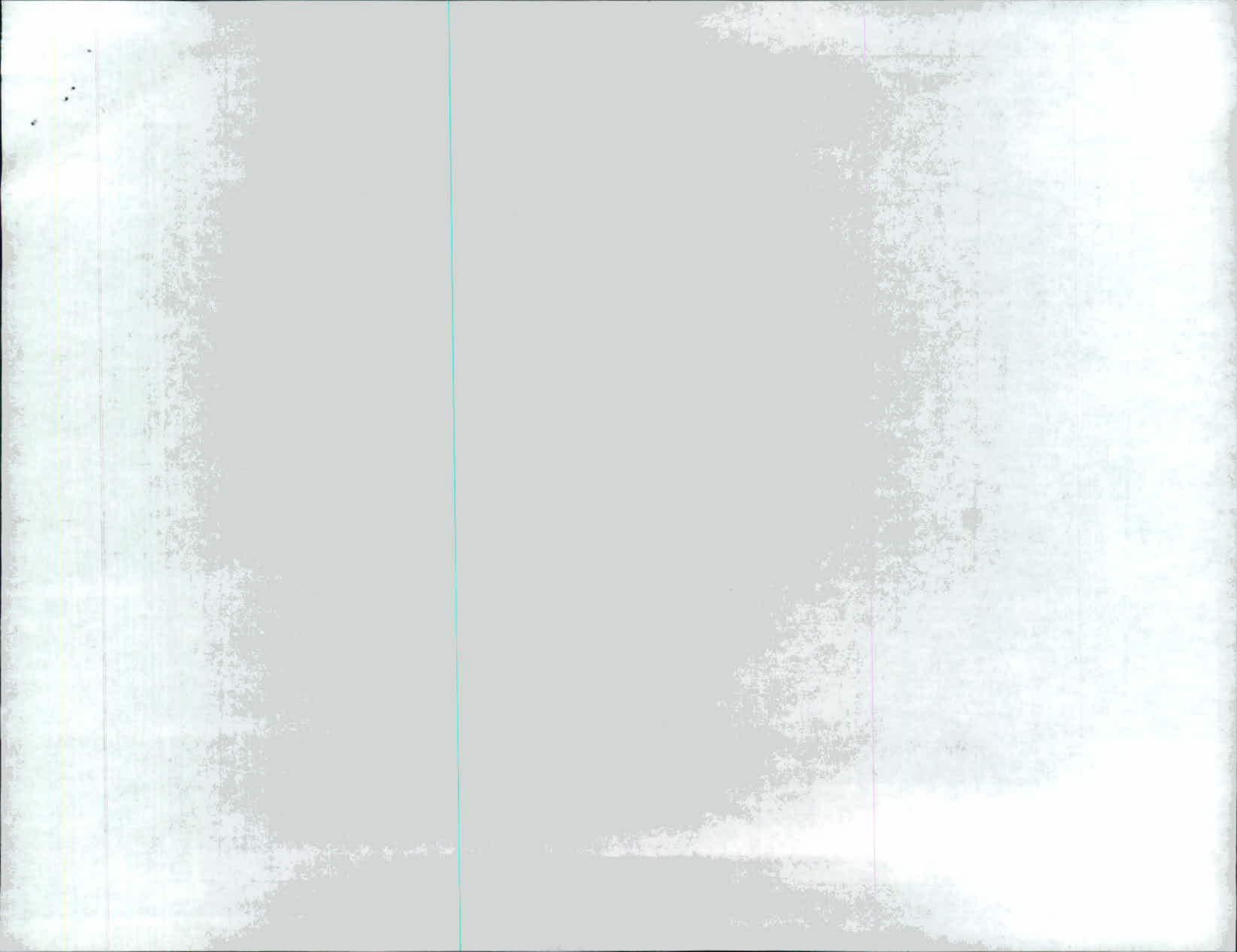


MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 42316



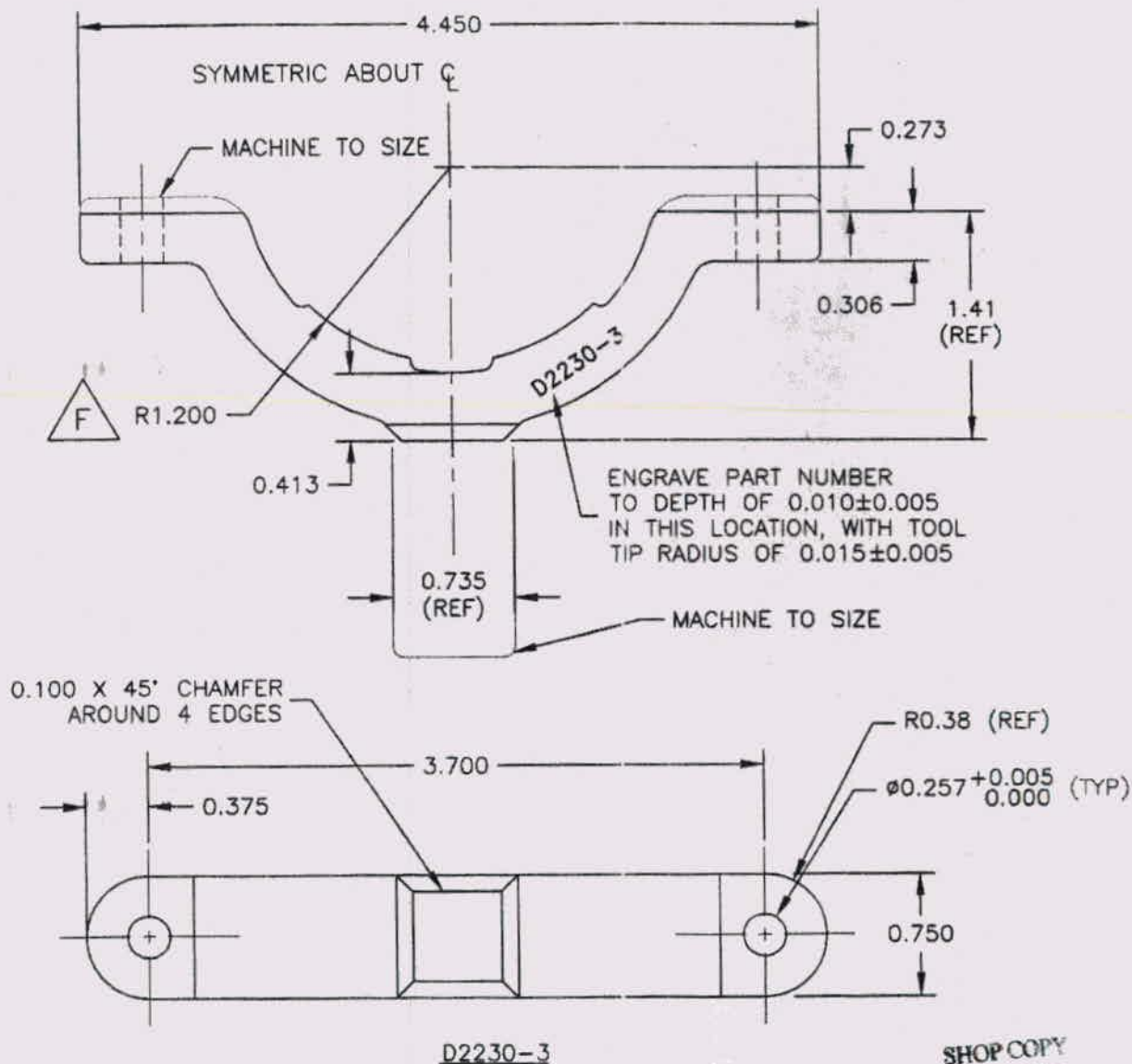






DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 42300





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-3

Lug

*Signature*  
08/12/14

7300

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Signature*  
Shigi Walz

Vankleek Hill, December 11, 2008



